

To ship Feb 25

Work Order ID 141936

141936

Page 1

February 22, 2016 3:42:30 PM

Item ID: D4888-041L02 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Dome Light Air Vent Assembly, Black
 Start Date: 2/22/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 2/25/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 20160222 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4888	A

100		0.00							DAS 6 9-89
100									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								

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110		0.00							DAS 07 9-89
110									
Small Fab	Memo	0.03							
Small Fab	Assemble as per Dwg D4888-041								

X2

16/02/24

- 1) Install air vents
- 2) Install lights
- 3) Install rheostats
- 4) Install wiring harness

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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141936

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Item ID: D4888-041L02

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Dome Light Air Vent Assembly, Black

Stop ***NS2***

Start Date: 2/22/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/25/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							DAS 38 9-89
Quality Control									FEB 25 2016
130	Identify as per dwg & Stock Location: <u>MF008</u>	0.00							
130									
Packaging	Memo	0.00							
Packaging									2 FEB 25 2016 DAS 6 9-89
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									MCS FEB 25 2016

MCS FEB 25 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					

Root Cause		FAULT CATEGORY					
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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Page 1

Work Order ID: 141936

141936

Parent Item: D4888-041L02

D4888-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 2/22/2016

Required Date: 2/25/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev A New Issue 13/09/13 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4886-1		Manufactured	No			100	Each	7.0000	2	4			
D4886-1									**				DAS
Air Vent													6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				MF005				7					
				127803				7					
D4888-1L02		Manufactured	No			100	Each	0.0000	1	2			DAS
D4888-1L02									**				6 9-89
Dome Light Housing, Black													
D4897-041		Manufactured	No			100	Each	3.0000	1	2			DAS
D4897-041									**				6 9-89
Dome Light Wiring													
				<u>Location</u>				<u>Loc Qty</u>					
				MF007				3					
				133482				3					
D4898-1		Manufactured	No			100	Each	102.0000	12	24			DAS
D4898-1									**				6 9-89
Screw, Stainless Steel													
				<u>Location</u>				<u>Loc Qty</u>					
				MF006				102					
				127703				2					
				141124				100					

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Picklist Print

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Work Order ID: 141936

141936

Parent Item: D4888-041L02

D4888-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 2/22/2016

Required Date: 2/25/2016

Start Qty: 2.00

Required Qty: 2.00

D4906-1 Manufactured No

100 Each 9.0000 1 2

D4906-1

Knob

Location

Loc Qty

Loc Code

MF006

9

128364

9

MS21042L06

Purchased No

100 Each 217.0000 12 24

MS21042L06

Nut

Location

Loc Qty

Loc Code

ST303

217

m133932

17

m134063

100

m134294

100

NAS1149F0663P

Purchased No

100 Each 81.0000 3 6

NAS1149F0663P

WASHER

Location

Loc Qty

Loc Code

st268

81

M132823

81

NAS1149FN632P

Purchased No

100 Each 115.0000 12 24

NAS1149FN632P

Washer

Location

Loc Qty

Loc Code

st268

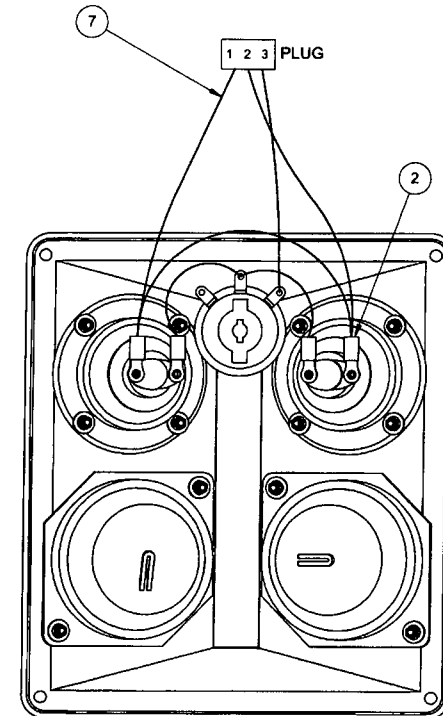
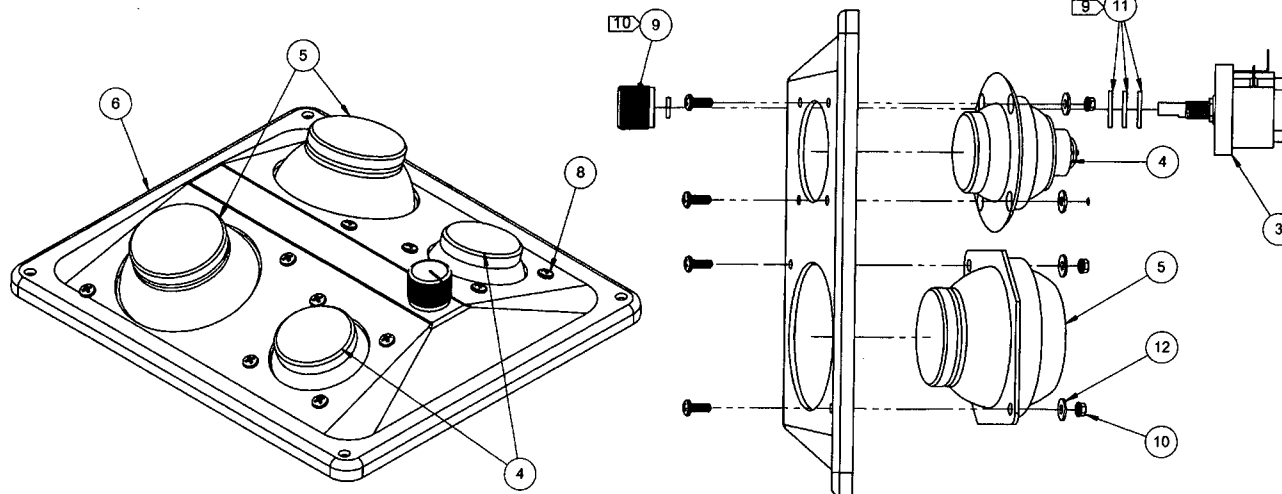
115

m129163

115

FEB 24 2016

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4888-041	DOME LIGHT AIR VENT ASSEMBLY
2	4	D4290-21 (REF)	RING TERMINAL (PART OF D4897-041)
3	1	D4864-1 (REF)	RHEOSTAT (PART OF D4897-041)
4	2	D4872-1 (REF)	LIGHT FIXTURE (PART OF D4897-041)
5	2	D4886-1	AIR VENT
6	1	D4888-1	DOME LIGHT HOUSING
7	1	D4897-041	DOME LIGHT WIRING HARNESS
8	12	D4898-1	SCREW
9	1	D4906-1	KNOB
10	12	MS21042L06	NUT
11	3	NAS1149F0663P	WASHER
12	12	NAS1149FN632P	WASHER



RELEASED
2013-09-16
WD

D4888-041 DOME LIGHT AIR VENT ASSEMBLY

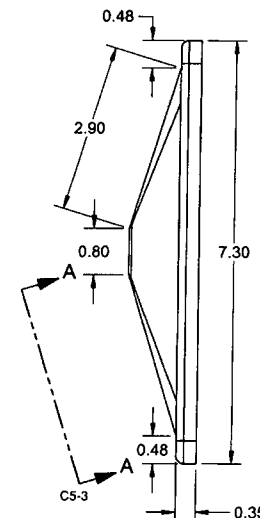
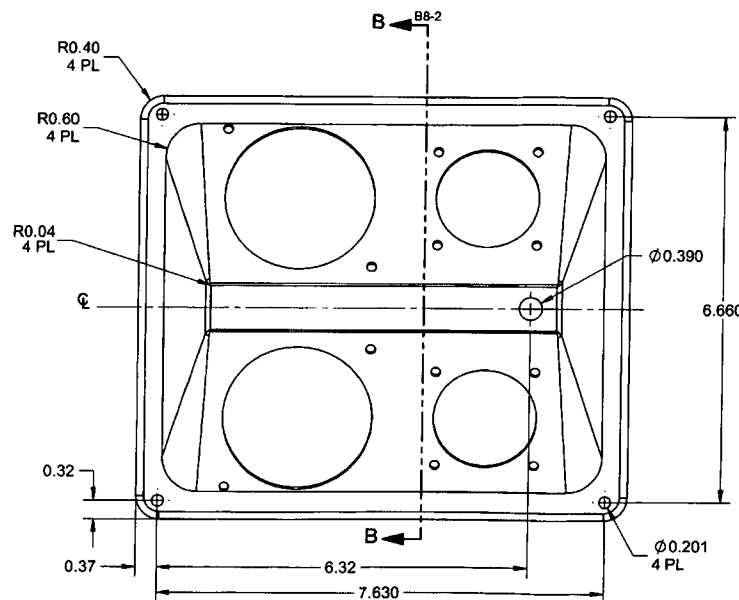
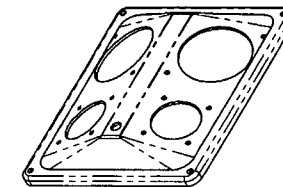
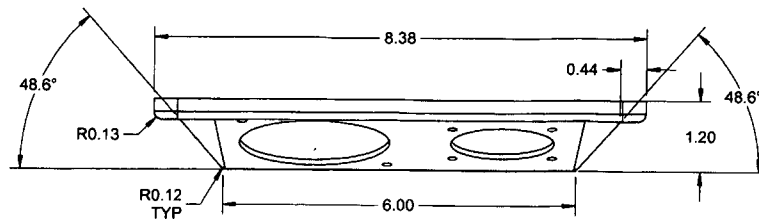
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) REPLACES GENEVA P/N GA129-12 P112-L
- 9) OPTIONAL: USE ADDITIONAL WASHERS TO SHIM AS REQUIRED
- 10) NUT INCLUDED WITH RHEOSTAT

20160222
SA 141936

REV.	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN	OS	DART AEROSPACE USA, INC. KENT, WA	OS	13.07.11
DRAWN	OS		REV. A	
CHECKED	DC		DRAWING NO.	SHEET 1 OF 3
MFG. APPR.	DC		D4888	SCALE
APPROVED	DC		TITLE	NTS
DE APPR.	DC	DOME LIGHT AIR VENT ASSY		
DATE	13.07.11			

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SECTION B-B

B5-2

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) TOOLING: THERMOFORM PER MOLD DT9932 PER QSI 022 TRIM PER DT9932
- 3) FINISH: N/A
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: 0.22 lbs
- 9) REPLACES GENEVA P/N GA129-7
- 10) PART SHAPE AND GEOMETRY IS CONTROLLED BY TOOLING
- 11) MINIMUM THICKNESS AFTER FORMING IS 0.060" FOR FLANGES AND 0.070" ELSEWHERE

D4888-1 DOME LIGHT HOUSING

PART NUMBER	DESCRIPTION
D4888-1LBL	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-02)
D4888-1LLG	F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)

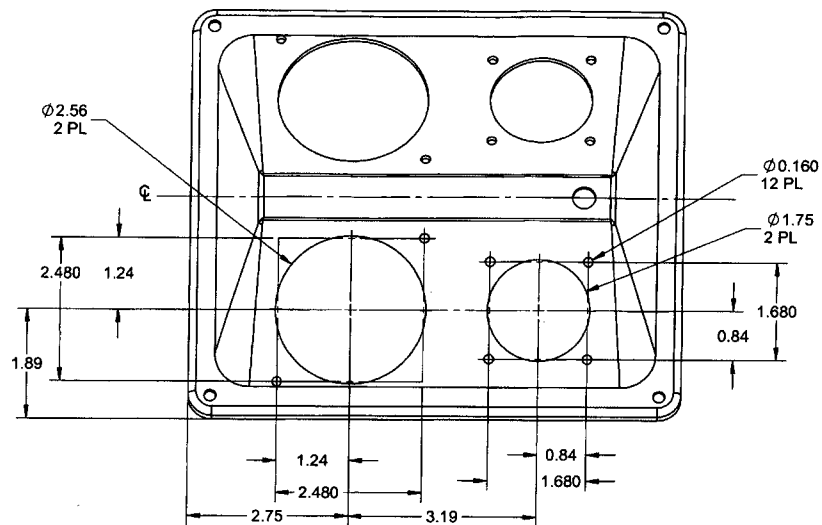
DESIGN	03
DRAWN	03
CHECKED	03
MFG. APPR.	03
APPROVED	03
DE APPR.	03
DATE	13.07.11

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO. **D4888** REV. A
SHEET 2 OF 3
TITLE **DOME LIGHT AIR VENT ASSY** SCALE NTS

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2013-09-16



VIEW A-A
B2-2

RELEASED
2013-09-16
AD

DESIGN	OS	DART AEROSPACE USA, INC.	
DRAWN	OS	KENT, WA	
CHECKED	PC	DRAWING NO.	REV. A
MFG. APPR.	PC	D4888	SHEET 3 OF 3
APPROVED	PC	TITLE	SCALE
DE APPR.	PC	DOMELIGHT AIR VENT ASSY	NTS
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